



Dart Aerospace Ltd.
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AUG 14 2018

005171

D119-675-111
Job Sheet 181778



Part No: D119-675-111

Job Qty: 2 ea

Part Name: Heli-Access-Step™ LH - DART Crosstube Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/8/18

Job Tracking No:

Due Date: 10/24/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP REV:A 15.11.09 PER IIN REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	10/24/18	10/24/18	0.00	0.00	Start Up Stores/Pkg-1		AUG 27 2018
110	Packaging	2 pcs	10/24/18	10/24/18	0.00	0.00	Packaging1-1		OCT 12 2018
120	QC	2 pcs	10/24/18	10/24/18	0.00	0.00	QC4	9-89	OCT 16 2018
125	DC	2 pcs	10/24/18	10/24/18	0.00	0.00	DC	9-89	OCT 16 2018
130	Packaging	2 pcs	10/24/18	10/24/18	0.00	0.00	Packaging3-1	9-89	OCT 16 2018
140	QC21-FG	2 Ea	10/24/18	10/24/18	0.00	0.00	QC21	21 9-89	OCT 17 2018

Part Op 125 - Photocopy bluefile & type labels per PPP D119-675-111 CHG001

Descriptions: 130 - Identify and pack for shipping as per PPP D119-675-111 Location : FG081

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-15A	Bolt	8 Ea (4 ea)	90-Start up Operation	5101850 x 4 5083012x4
AN4-16A	Bolt	8 Ea (4 ea)	90-Start up Operation	5082909
AN4-22A	Bolt	8 Ea (4 ea)	90-Start up Operation	5097470
D2617-3	Bushing	8 Ea (4 ea)	90-Start up Operation	7142939
D2617-5	Spacer	8 Ea (4 ea)	90-Start up Operation	7140822
D2732-032	Rubber Cushion - 3.2"	16 Ea (8 ea)	90-Start up Operation	5102362x1 5105637x7
D3043-041	Step Weldment LH	2 Ea (1 ea)	90-Start up Operation	5113158
D5283-041	Basket Clamp Assembly	4 Ea (2 ea)	90-Start up Operation	5002174
D5283-043	Basket Clamp Assembly	4 Ea (2 ea)	90-Start up Operation	5085198 5109625
D5283-11	Basket Clamp	4 Ea (2 ea)	90-Start up Operation	5101206
D5283-7	Basket Clamp	4 Ea (2 ea)	90-Start up Operation	5102241x2 5106079x1
MS21042L4	Nut	24 Ea (12 ea)	90-Start up Operation	5089305
NAS1149D0463J	Washer	48 Ea (24 ea)	90-Start up Operation	5089299

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-15A	8	413	0
	AN4-16A	8	709	0
	AN4-22A	8	246	0
	D2617-3	8	23	0
	D2617-5	8	47	0
	D2732-032	16	51	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Storage ☐ Engineering ☐ Quality ☐ Other ☐		
Date : _____	Step #: _____	QTY Effective : _____		
Description Work Order Deviation		Disposition		

DART AEROSPACE
 Container No: S117889
 Part: D119-675-111
 Job No: 181778
 Serial No/Batch: S117889
 Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: FAA STC SR00948SE 15/08/2016 LOA C-11

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Pow ☐	rong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folic ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

D3043-041	2	0	0
D5283-041	4	15	0
D5283-043	4	9	0
D5283-11	4	11	0
D5283-7	4	11	0
MS21042L4	24	6,194	0
NAS1149D0463J	48	10,335	0

Part Specifications

Specifications could not be found.

Plex 8/8/18 12:52 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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5.0 PARTS LISTS

5.1 Heli-Access-Step™ Parts List

ITEM	Qty -011	Qty -012	Qty -111	Qty -112	Part Number	Description
	X				D119-675-011	HELI-ACCESS-STEP™, LH
		X			D119-675-012	HELI-ACCESS-STEP™, RH
			X		D119-675-111	HELI-ACCESS-STEP™, LH
				X	D119-675-112	HELI-ACCESS-STEP™, RH
1	4	4	4	4	D2617-5	BUSHING
2	4	4	4	4	D2617-3	BUSHING
3	8	8	8	8	D2732-032	RUBBER CUSHION
4	1		1		D3043-041	STEP WELDMENT LH
5		1		1	D3043-042	STEP WELDMENT RH
6	4	4			D3041-1	CLAMP
7	2	2			D3041-3	CLAMP
8	4	4			D3041-5	CLAMP
9	2	2			D3041-7	CLAMP
10			2	2	D5283-7	CLAMP
11			2	2	D5283-11	CLAMP
12			2	2	D5283-041	CLAMP
13			2	2	D5283-043	CLAMP
14	4	4	4	4	AN4-15A	BOLT
15	8	8	4	4	AN4-16A	BOLT
16			4	4	AN4-22A	BOLT
17	24	24	24	24	NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12	MS21042L4	NUT (OR MS21042-4)

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Revision: C

Date: 15.07.20

Change Record

PAGE 1 OF 1

Part Number: D119-675-111/-112

Description: HELI ACCESS STEP, LH/RH

[illegible]